

Date: Wednesday, 9/26/2007 2:09:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BACK PANEL
Job Number	34898		
Estimate Number	11093		
P.O. Number	:	Part Number	D30231
This Issue	9/26/2007	S.O. No.	D3023 REV A
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	A
Previous Run	33367	Material	:
Written By		Due Date	10/15/2007
Checked & Approved By		Qty:	1 Um: Each
Comment	Est. C 02.01.23 Revised NG		

## Additional Product

Job Number:



30 min

18/04/2008

Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S032	2024-T3 .032 sheet	  Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: H106072
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	  Comment: LARGE FABRICATION RESOURCE 1 1-Trace and Cut Out Panel Using DT8621 Jig PD 08-04-15 2-Drill Using Dt8621 PD 08-04-15 3-Deburr Form as per drawing A3023 SB 08/04/16
3.0	QC5	INSPECT WORK TO CURRENT STEP	  Comment: INSPECT WORK TO CURRENT STEP 08/04/17 (1)
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 FD 08/04/17 (1)
5.0	POWDER COATING	POWDER COATING	  Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 BR 08-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 34898

Part Number: D30231

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23 (1)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/04/23 (2)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24 (3)

Job Completion



MF 08-04-23

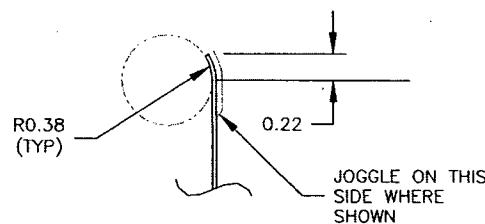
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

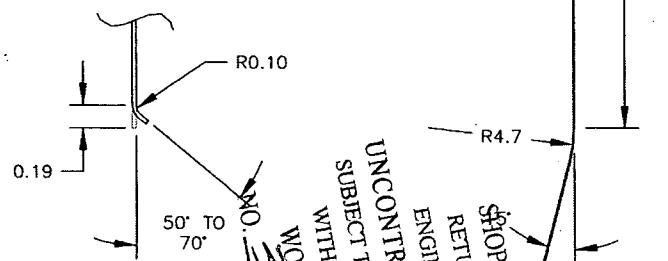
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)



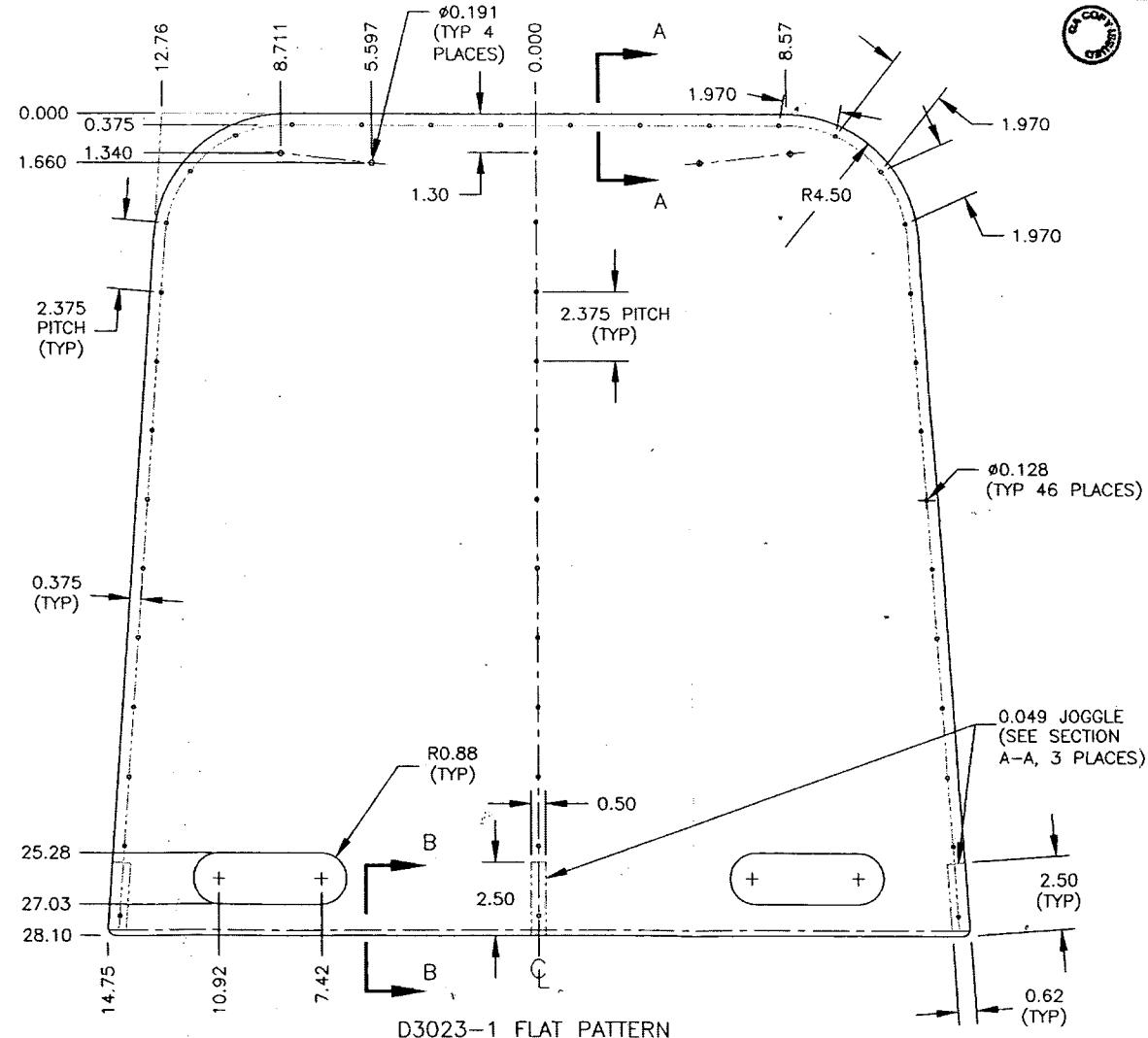
SECTION B-B  
SCALE 1:1  
(BOTTOM EDGE ONLY)



RELEASED  
9-06-07

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
  - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
  - 3) ALL DIMENSIONS ARE IN INCHES.
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



D3023-1 FLAT PATTERN

A		01.05.18	NEW ISSUE
DESIGN	<i>SP</i>	DRAWN BY	<i>SP</i>
CHECKED	<i>SP</i>	APPROVED	<i>SP</i>
		DRAWING NO.	REV. A
		D3023	SHEET 1 OF 1
DATE	01.05.18	TITLE	SCALE
		BACK PANEL	1:4

**DART AEROSPACE LTD.**  
HAWKSBURY, ONTARIO, CANADA